











Date: Wednesday, 11/03/2009 12:58:51 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 46434		
Estimate Number	: 10993		
P.O. Number	:	Part Number	: D2579
This Issue	: 11/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2579 REV E
First Issue	: / /	Project Number	: N/A
Previous Run	: 43988	Drawing Revision	: E
		Material	:
Written By	:	Due Date	: 04/04/2009
Checked & Approved By	: <u>JUD 09.03.11</u>	Qty:	200
Comment	: Est E 02.06.17 Now turned on Cobra NG est F 07.07.06 rev E dwg EC	Um:	Each

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0500W058	6061-T6 RD Tube .500 x.058W
		
Comment: Qty.: 0.3762 f(s)/Unit Total: 75.2430 f(s) , 757 ft (ends) 6061-T6 Tube .500 x.058W Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) 0.500 Dia x 0.058 Wall Batch <u>M110355</u> <u>09/03/13</u> <u>200 pcs</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		
Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA245 <u>09/03/13</u> <u>200 pcs</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>09/03/13</u> <u>200 pcs</u>		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <u>J.L 09/03/13</u>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Bachy</u> <u>9/13/11</u> <u>2000</u> <u>SP</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CROSSBOLT SPACER

Job Number: 46434

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



200

Comment: FINAL INSPECTION/W/O RELEASE

AD 09/03/15

Job Completion



u 9.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

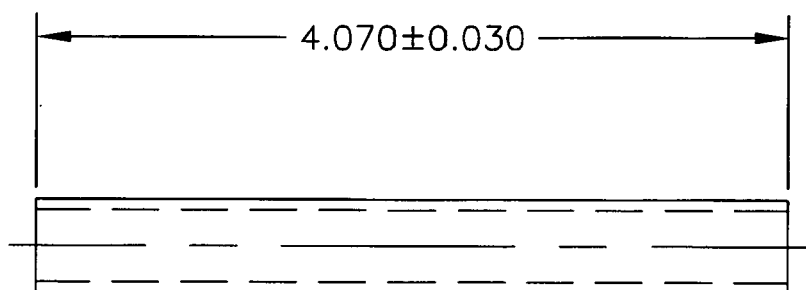
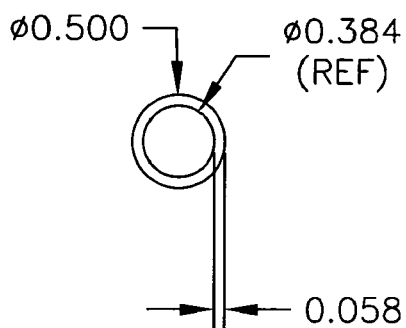
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2579	REV. E SHEET 1 OF 1
DATE 07.04.17			TITLE CROSS BOLT SPACER SCALE 1:1		
A	96.09.16			NEW ISSUE	
B	96.12.05			0.065 WALL WAS 0.035 WALL	
C	97.02.21			0.058 WALL WAS 0.065 WALL	
D	99.05.19			4.070 LENGTH WAS 4.100 (TSR A1095)	
E	07.04.17			UPDATE NOTES	

RELEASED
07.06.28



D2579 CROSS BOLT SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46434

D2579 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T0500W058)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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